

Work Order ID 84384

May-11-12 7:20:10 AM

Ship May 17!
84384

Page 1

Item ID: D350-591-113

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Heli-Access-Step, Short

Stop

NS2

Start Date: 5/11/12 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/17/12 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

u

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2310	D
DSI 9525	A

100

100

DOCUMENT CONTROL

DC

Document Control

sf

0.00

4

WHL 12-05-17

110

110

Large Fab

Large Fab

Large Fab

Memo

0.00

0.00

1-Cut D2244 extrusion to 62.00" long as per Dwg D2310
2-Drill extrusion as per Dwg D2310 using drill Jig DT8230
3-Deburr

4

6

sf Ae

12-05-12

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NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

120

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

5/11/14

74

130

130

Large Fab

Large Fab

0.00

12.05.14

4 φ

12.05.14

Large Fab

Memo

0.00

1-Weld Fwd end cap and bushing as per Dwg D2310
A/R AL ROD Batch: 119785
2-Grind end cap and bottom bushing welds flush
3-Machine top weld on bushing flush

140

140

QC

QC9- Inspect visual per QSI004- Fusion Welds

0.00

12.05.14

0.00

4 φ

12.05.14

Quality Control

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Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

150

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8/2/05

40

160

160

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

④

16/05/15

170

170

Large Fab

Large Fab

Large Fab

0.00

Memo

0.00

1-Rivet as per Dwg D2310

2-Inspect for foreign object as per QSI 024

3-Weld Aft end cap as per Dwg D2310

A/R AL ROD Batch: 119783

4-Grind end, cap welds flush 120864

4

0

12.05.15

12.05.15

Ae
12.05.15

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Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

0.00

50000000

0.00

180

180

QC

Quality Control

190

QC5- Inspect part completeness to step on W/O

0.00

50000000

0.00

190

QC

Quality Control

200

Chemical Conversion Coat per QSI005 4.1

0.00

50000000

0.00

200

HandFinish

Hand Finishing

(XL)

(4) 2012-5-15

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Reference:

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Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

210

Powdercoat

Powder Coating

W121134

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2~45 0.00
320°F
3~15

4X 0

ML
12/5/16

220

220

HandFinish

Hand Finishing

Memo

0.00

4 0 12/5/17

230

230

QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

12/5/17

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Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

240

240

Packaging

Packaging

Pick Kit

0.00

(4)

10/13/12

250

250

QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

(4)

mh/12.05.17

260

260

Packaging

Packaging

PACKAGING RESOURCE #1

0.00

Memo

0.00

Identify and pack for shipping as per PPP D350-591-113
Location: _____

(4)

10/13/12

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Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

270

QC21- Final Inspection - Work Order Release

0.00

270

QC

Quality Control

Memo

0.00

MWJ 12/05/12

U120517

Picklist Print

May-11-12 7:20:09 AM

Page 1

Work Order ID: 84384

Parent Item: D350-591-113

Start Date: 5/11/12

Required Date: 5/17/12

Parent Item Name: Heli-Access-Step, Short

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:H04.11.09ReformatKJ/JLM
DD verf:EC

IPP Rev:E as per ECN10-586 10.06.18

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2244-116 Step Extrusion		Manufactured	No			110	Each	80.5000	1	4		<i>Ac 12.05.12</i>	

Location Loc Qty Loc Code

WA 80.5
80803 80.5

D2275 Bushing		Manufactured	No			130	Each	13.0000	1	4		<i>Ac 12.05.14</i>	
------------------	--	--------------	----	--	--	-----	------	---------	---	---	--	--------------------	--

Location Loc Qty Loc Code

WA015 13
72832 13

D2582 Step Leg Assembly		Manufactured	No			170	Each	15.0000	1	4		<i>Ac 12.05.15</i>	
----------------------------	--	--------------	----	--	--	-----	------	---------	---	---	--	--------------------	--

Location Loc Qty Loc Code

WA014 15
72804 8
72828 7

D2673-34 End Plate		Manufactured	No			130	Each	30.0000	2	8		<i>Ac 12.05.15</i>	
-----------------------	--	--------------	----	--	--	-----	------	---------	---	---	--	--------------------	--

Location Loc Qty Loc Code

WA 10
81468 10
WA015 20
59690 20

K591-113 Short Step Instln Kit		Manufactured	No			240	Each	0.0000	1	4		<i>SP 84385 12/5/17</i>	
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Picklist Print

Page 2

May-11-12 7:20:09 AM

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Parent Item: D350-591-113

Parent Item Name: Heli-Access-Step, Short

Start Date: 5/11/12

Required Date: 5/17/12

Start Qty: 4.00

Required Qty: 4.00

MS20600-AD4W3

Purchased

No

170

Each

976.0000

16

64

Cherry Rivets

Ac 12.05.15

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	ST321	843	
	111636	36	
	117601	3	
	118626	482	
	<u>120308</u>	322	<u>64</u>
	WA018	133	
	107939	133	

DART

DESIGN KE	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>ff</i>	APPROVED <i>ff</i>	DRAWING NO. D2310	REV. D SHEET 1 OF 2
DATE 05.11.14	TITLE HIGH SHORT STEP ASSEMBLY		SCALE NTS
A	94.11.10	NEW ISSUE	
B	97.05.22	END CAPS CHANGED	
C	97.07.23	ADDED BUSHING AND FACING INFO	
D	05.11.14	UPDATE FINISHING NOTE	

D2310 HIGH SHORT STEP ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2310	High Short Step Assembly	X
D2244-62.0	STEP EXTRUSION*	1
D2275	BUSHING	1
D2582	STEP LEG ASSEMBLY	1
D2673-34	STEP END PLATE	2
MS20600AD4W3	Rivets	16

*cut per drawing

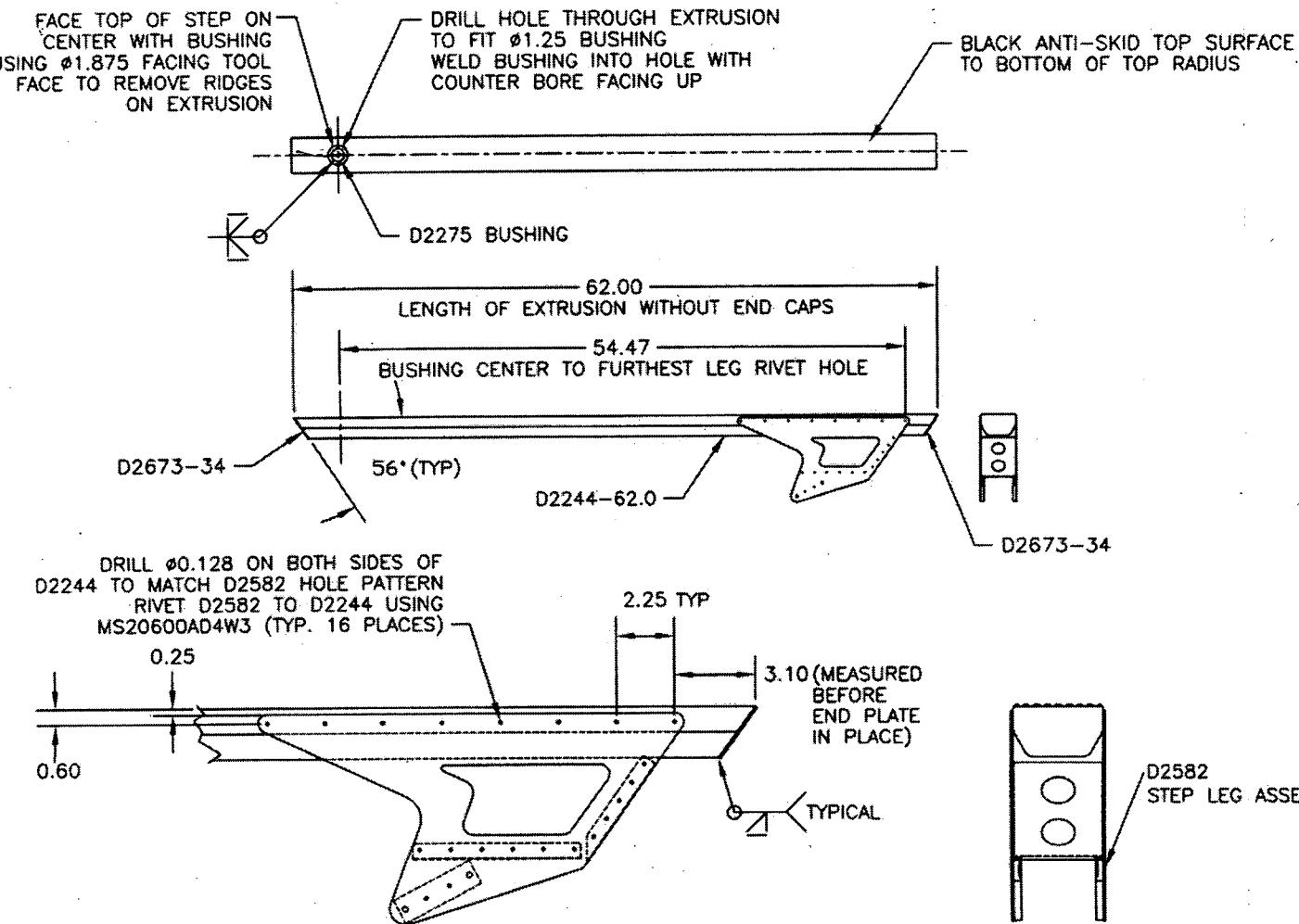
RELEASED
05.11.28 *ff*

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DART

DESIGN KE	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2310
DATE 05.11.14		TITLE HIGH SHORT STEP ASSEMBLY



STEP LEG DETAIL

D2310 HIGH SHORT STEP ASSEMBLY

- 1) MAKE FROM D2244 STEP EXTRUSION
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05.11.28